

# Work Order ID 78477

January-10-12 9:52:24 AM

**\*78477\***

Page 1

Item ID: D2916-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cable Guard, 212 Skitube  
 Start Date: 10/01/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 24/01/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/10 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2916	Rev D

100 0.00  
**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D2916 Dwg Rev: D Prog Rev: D 2-  
 Deburr if necessary

B12-1-11

24

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

B12-1-11

120 0.00  
**\*120\*** HAAS CNC VERTICAL MACHINING #1  
 HAAS I Memo 0.00  
 HAAS CNC vertical machine #1 BATCH: 1-Mill as per Folio FB077 Rev: AA  
 & Dwg D2916 Rev: D 2-Deburr per dwg D2916

20/12/10

12/01/10

21

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector*
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 78477

\*78477\*

Parent Item: D2916-3

\*D2916-3\*

Parent Item Name: Cable Guard, 212 Skitube

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-19 JLM  
IPP Rev:B Now water jet 06-07-14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	559.6443	0.55	11.57895			

\*MUHMWB10\*

UHMW 1" Black

\*\*

1B12-1-11

Location

Loc Qty

Loc Code

MAT018

300

120035

300

MAT019

259.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

4.44431579

120035

(24)

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D2916-1  
 D2916-3  
 D2916-5  
 D2916-7

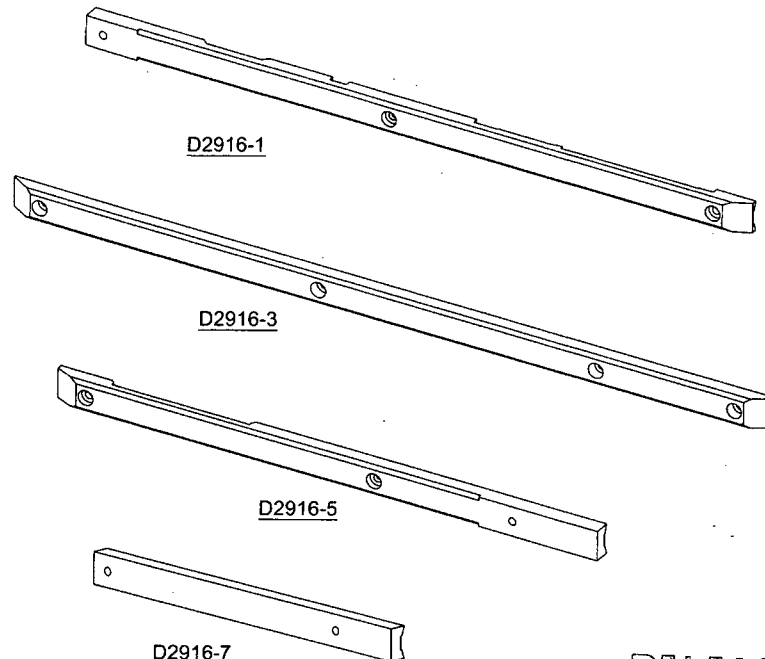
70477 M.C.J.  
 12/01/10

# NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL  
REF DART SPEC MUHMB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 6) IDENTIFICATION: ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010
- 7) WEIGHT:

D2916-1 = 1.37 lbs  
 D2916-3 = 2.33 lbs  
 D2916-5 = 1.19 lbs  
 D2916-7 = 0.96 lbs

- 8) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250
- 9) MACHINE CONSTANT SECTION A-A
- 10) MACHINE CONSTANT SECTION B-B
- 11) MACHINE CONSTANT SECTION C-C
- 12) MACHINE CONSTANT SECTION F-F
- 13) MACHINE CONSTANT SECTION G-G
- 14) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 15) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 16) MACHINE SLOT WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 17) ALL HOLES DRILLED ON CENTERLINES



RELEASED  
 2011-11-02  
 MJP

D	REVISE MACHINE SLOT. (ZN C5-2, C4-4, C4-5, C6-5) REVISE SECTIONS D-D, L-L, N-N	RF	11.10.07
C	REVISE D-D; ADD L-L, M-M & N-N; FOR D4406-041/-043 COMPATIBILITY	RF	11.08.17
B	ADD K-K FOR D2521 COMPATIBILITY	CP	00.02.24
A	NEW ISSUE	CP	99.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	4	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	4	DRAWING NO.	REV. D
MFG. APPR.	4	D2916	SHEET 1 OF 6
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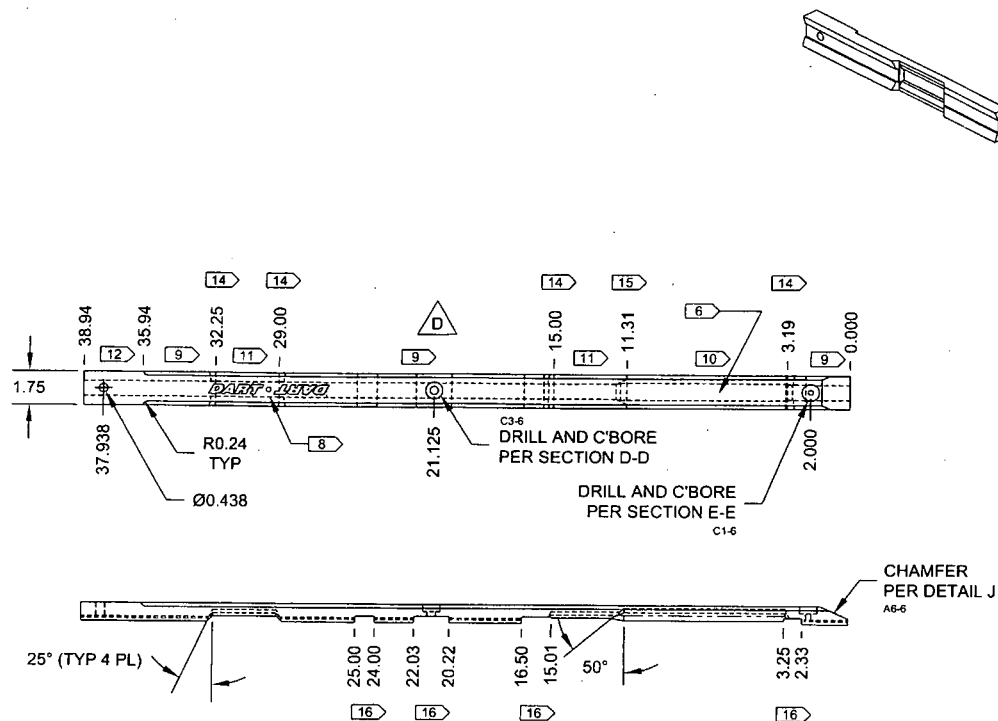
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**D2916-1**

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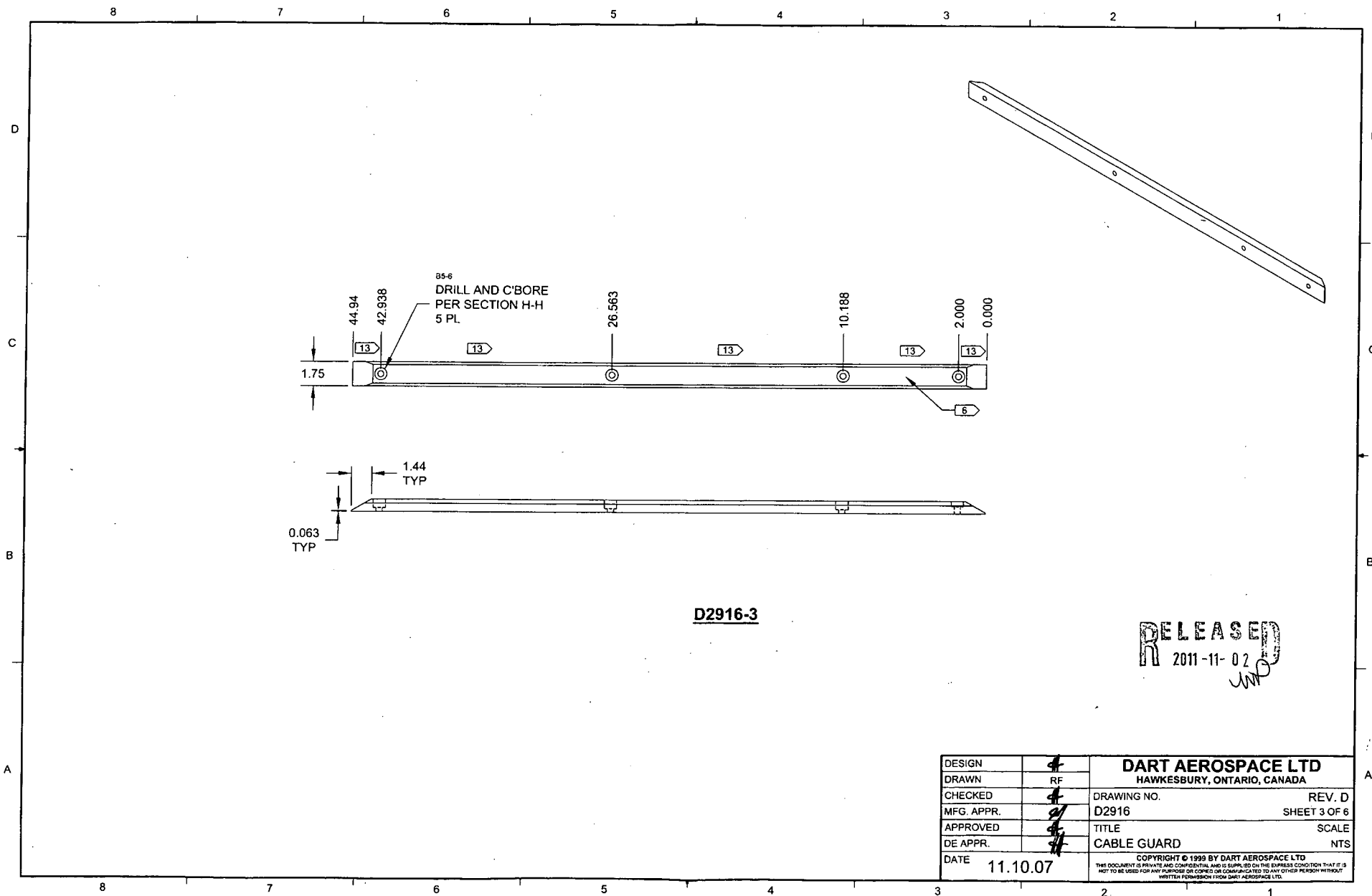
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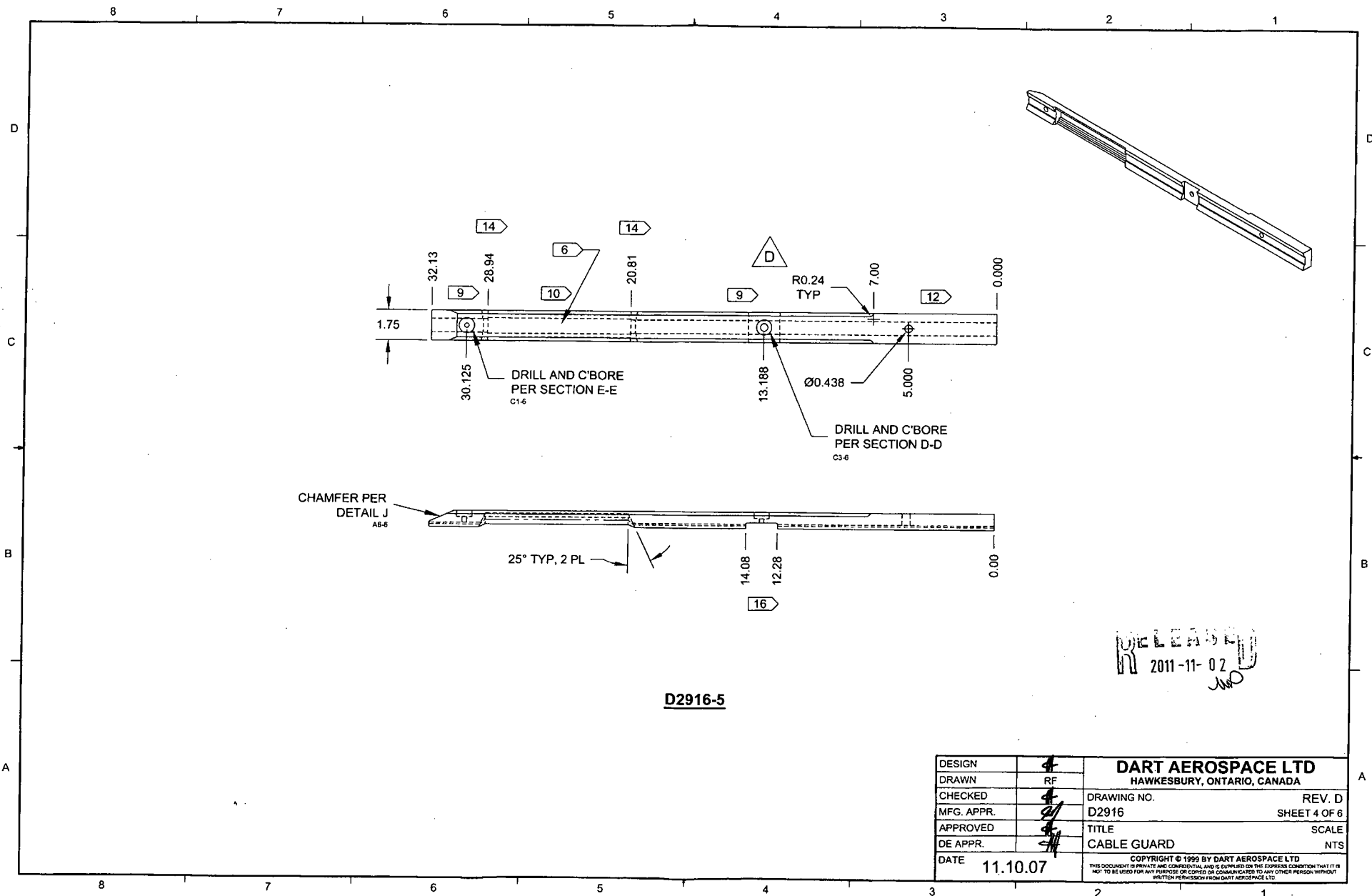
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D2916-5

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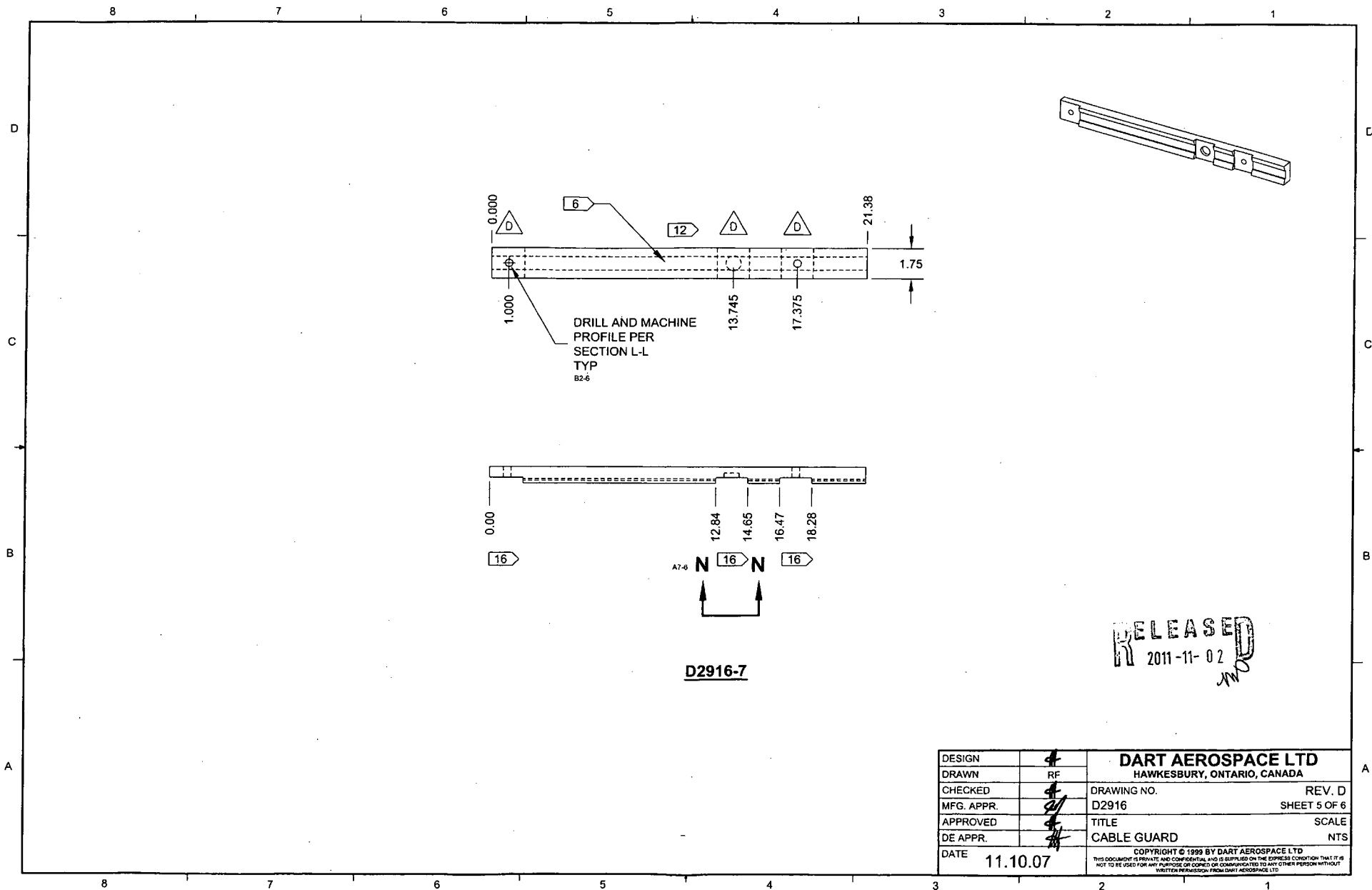
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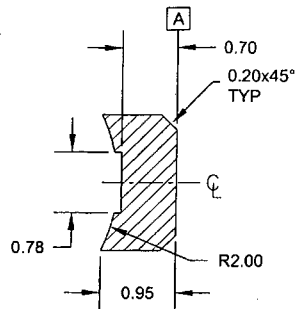
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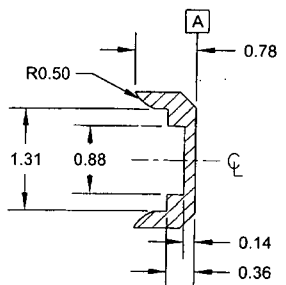
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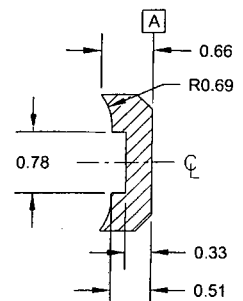
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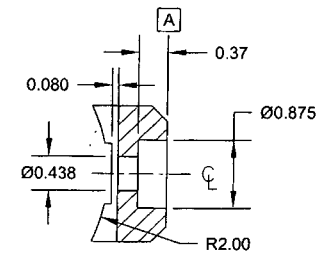
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C6-2  
C4-4  
C6-4



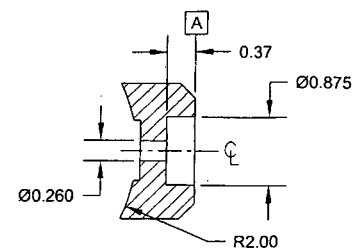
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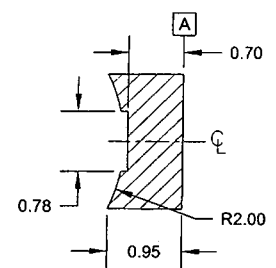
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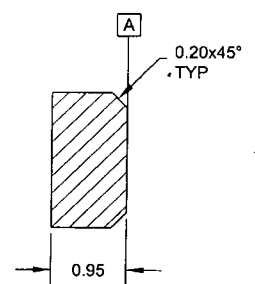
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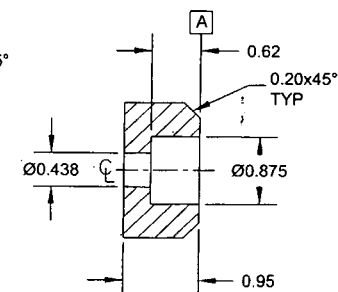
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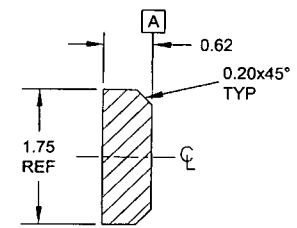
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C5-5



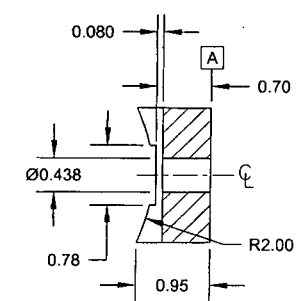
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C6-3  
C7-3



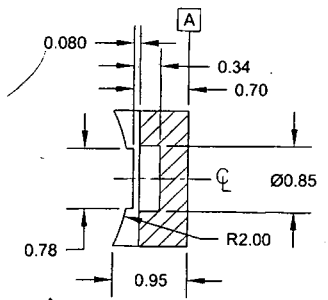
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C6-3



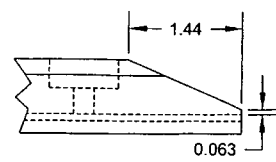
SECTION K-K  
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B3-2  
B4-2  
B5-2



SECTION L-L  
SCALE 4X  
C5-5



SECTION N-N  
SCALE 4X  
B6-5



DETAIL J  
SCALE 4X  
B3-2  
B7-4

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MFG. APPR.	<i>2</i>	D2916	SHEET 6 OF 6
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